drilling and reaming the bearing holes for the shafts passing through the work. In this particular case, however, they are used only for rough-drilling the holes, to allow the boring-bars to pass through when finishing the work by boring in a special boring jig, after the two parts of the work have been screwed together.

The large bushings shown beside the jig in Fig. n are the loose bushings shown in place in Fig. 12. It will be noted that the bushings are provided with dogs for easy removal, as explained in a following chapter. As the central portion of the

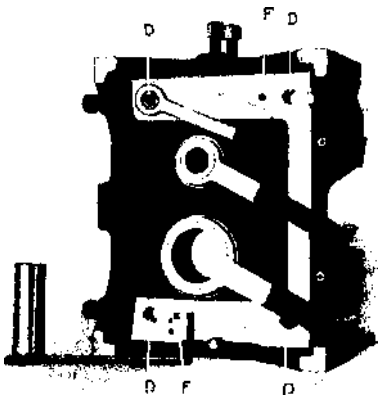

Fig. 12. Rear View of Drill Jig shown in Fig. u

jig body is rather thin, it will be seen from Fig. 12 that the bosses for the central holes project outside of the jig body in order to give a long enough bearing to the bushings. This, of course, can be done only when such a projection does not interfere with the work. The bosses, in this particular case, also serve another purpose. They make the jig "fool-proof," because the pieces drilled on the side of the jig shown in Fig. 11 cannot be put on the side shown in Fig. 12, the bosses preventing the piece from being placed in position in the jig.

Attention should be called to the simplicity of the design of this jig. It simply consists of a cast-iron plate, with finished seats, and feet projecting far enough to reach below the work